

Work Order ID 71697

Thursday, July 07, 2011 12:56:03 PM



Page 1

Item ID: D4000-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Drain Fitting Assembly, Fwd

Start Date: 7/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/07/07 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4000	A
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100 Weld per dwg A/R Aluminum rod Batch 114703 0.00



Large Fab

Memo

0.00

Large Fab

11.08.15 1 φ

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 φ BE 11/08/15

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

6 u/08/15

Ⓢ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71697

Thursday, July 07, 2011 12:56:03 PM



Page 2

Item ID: D4000-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Drain Fitting Assembly, Fwd

Start Date: 7/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

*11.08.15**1* *0*

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/8/18**11-08-16**(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:56:01 PM

Page 1

Work Order ID: 71697

Parent Item: D4000-043

Parent Item Name: Drain Fitting Assembly, Fwd



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.01.20 new issue Prelim EC verified by:DD IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4000-3 		Manufactured	No			100	Each	0.0000	1				
Fuel Sump Drain Fitting													
D4003-3 		Manufactured	No			100	Each	2.0000	1				
Internal Drain Line, Fwd													

11.08.15 8724500
11.08.15

Location

Loc Qty

Loc Code

ST105

2

65443

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

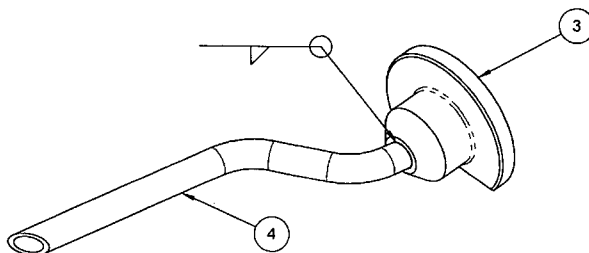
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

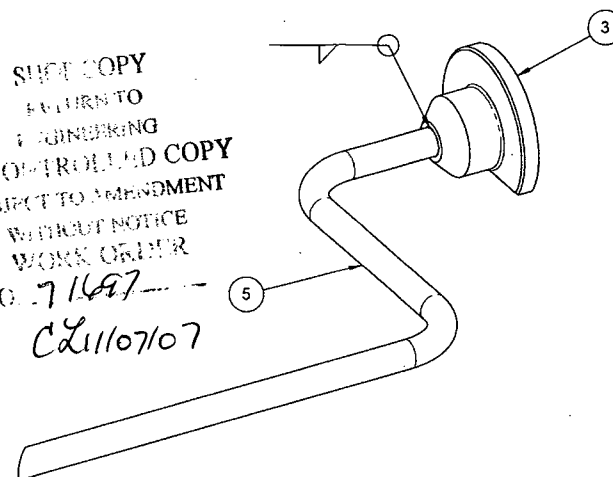
NOTE: Date & initial all entries

ITEM	QTY. -043	QTY. -045	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X		D4000-041	DRAIN FITTING ASSEMBLY, AFT	JCA-M47-1-06
2		X	D4000-043	DRAIN FITTING ASSEMBLY, FWD	JCA-M47-1-15
3	1	1	D4000-3	FUEL SUMP DRAIN FITTING	
4	1		D4003-1	INTERNAL DRAIN LINE, AFT	
5		1	D4003-3	INTERNAL DRAIN LINE, FWD	



D4000-041 DRAIN FITTING ASSEMBLY, AFT

SHUT COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 711697
 CL11/07/07



D4000-043 DRAIN FITTING ASSEMBLY, FWD

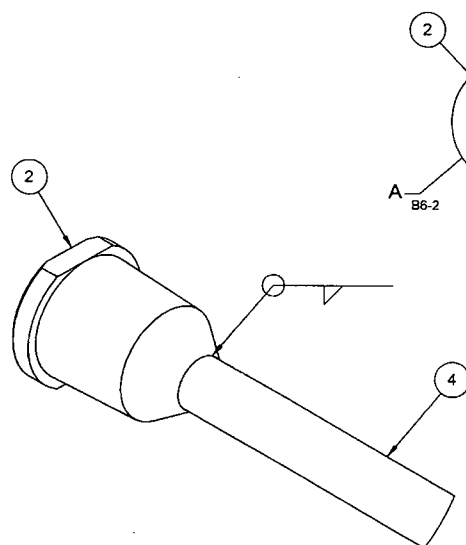
RELEASED
 2010-05-05
WP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-043/-045" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D4000-043 - 0.04 lbs
D4000-045 - 0.05 lbs

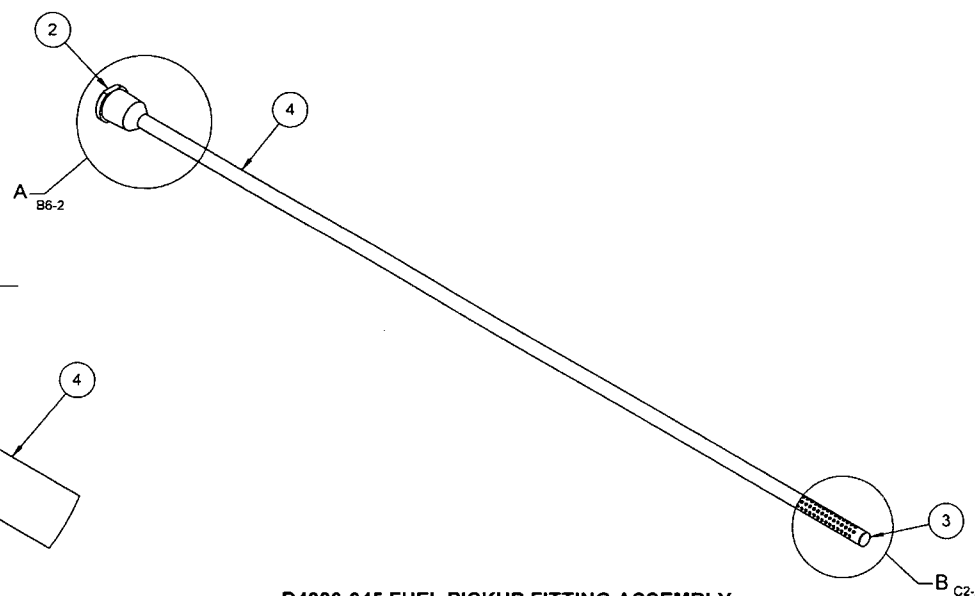
A	NEW ISSUE		10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4000	REV. A
TITLE FITTING	SCALE NTS
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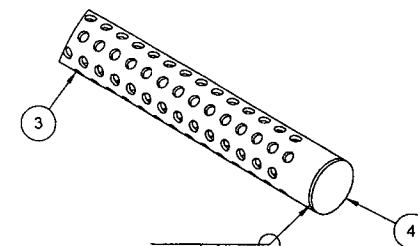
ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4000-045	FUEL PICK UP FITTING ASSEMBLY	JCA-M47-1-10
2	1	D4000-7	FUEL PICK UP FITTING	
3	1	D4000-11	CAP	
4	1	D4003-5	FUEL PICK UP LINE	



DETAIL A
SCALE 4X C6-2



D4000-045 FUEL PICKUP FITTING ASSEMBLY



DETAIL B
SCALE 4X B2-2

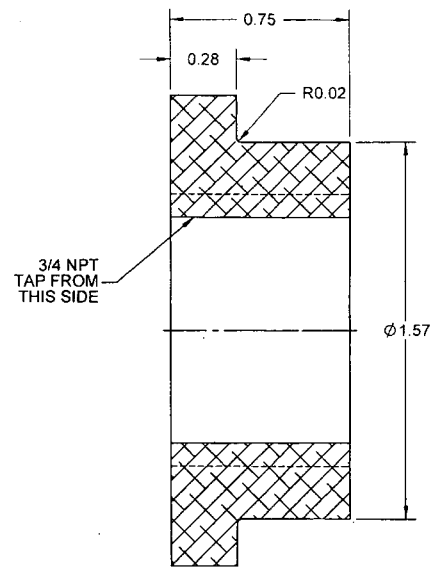
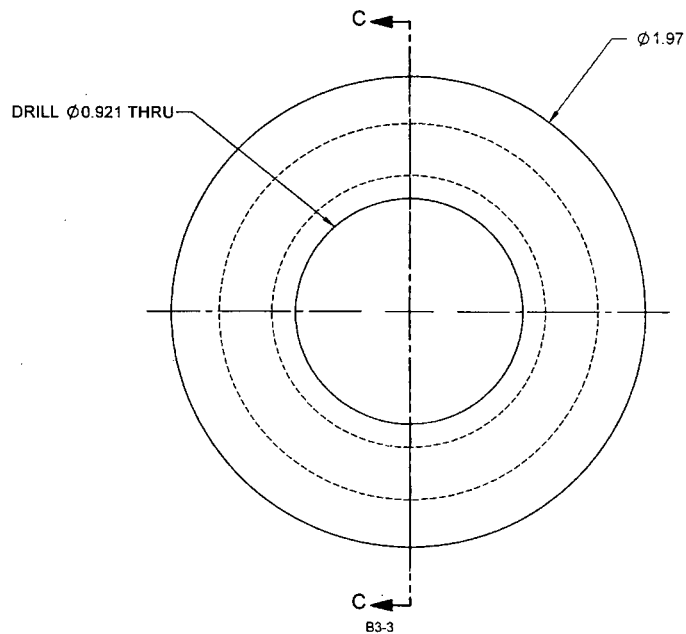
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-045" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

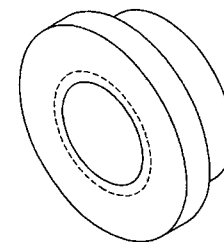
RELEASED
2010-05-05
JM

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 2 OF 8
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DE APPR.		FITTING	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-1	JCA-M47-1-04



SECTION C-C
B6-3



D4000-1 FUEL SUPPLY FITTING

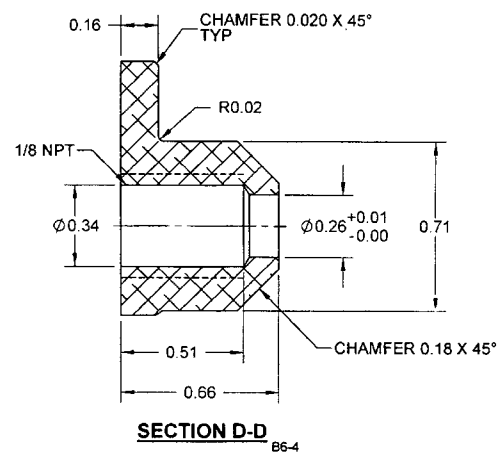
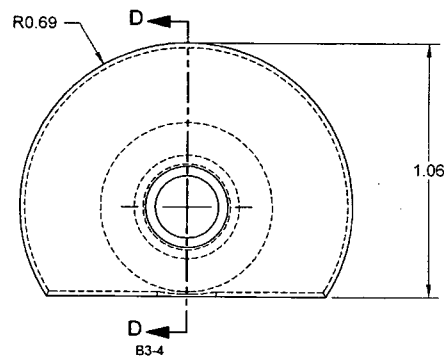
RELEASED
2010-05-05
WJP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4000	SHEET 3 OF 8
APPROVED	<i>WJP</i>	TITLE	SCALE
DE APPR.	<i>WJP</i>	FITTING	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-3	JCA-M47-1-05



D4000-3 FUEL SUMP DRAIN FITTING

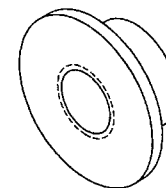
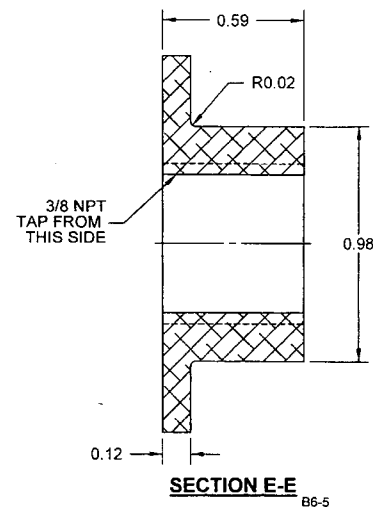
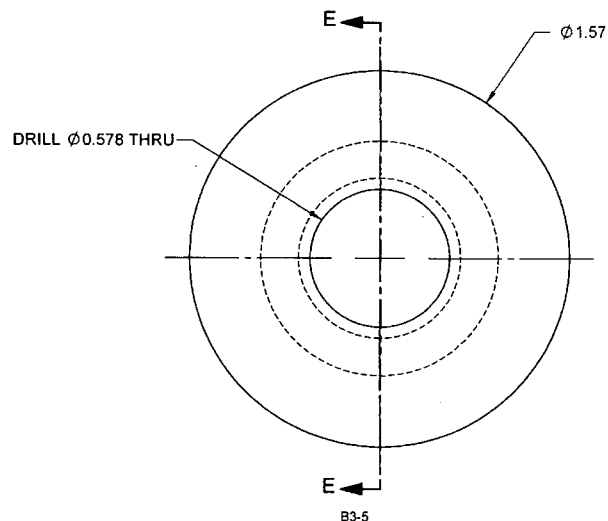
RELEASED
2010-05-05
mp

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4000	REV. A
MFG. APPR.		TITLE FITTING	SHEET 4 OF 8
APPROVED		SCALE	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-5	JCA-M47-1-09



D4000-5 FUEL TANK VENT FITTING

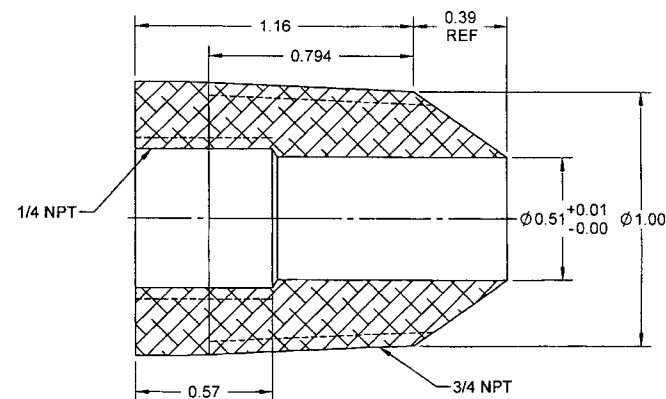
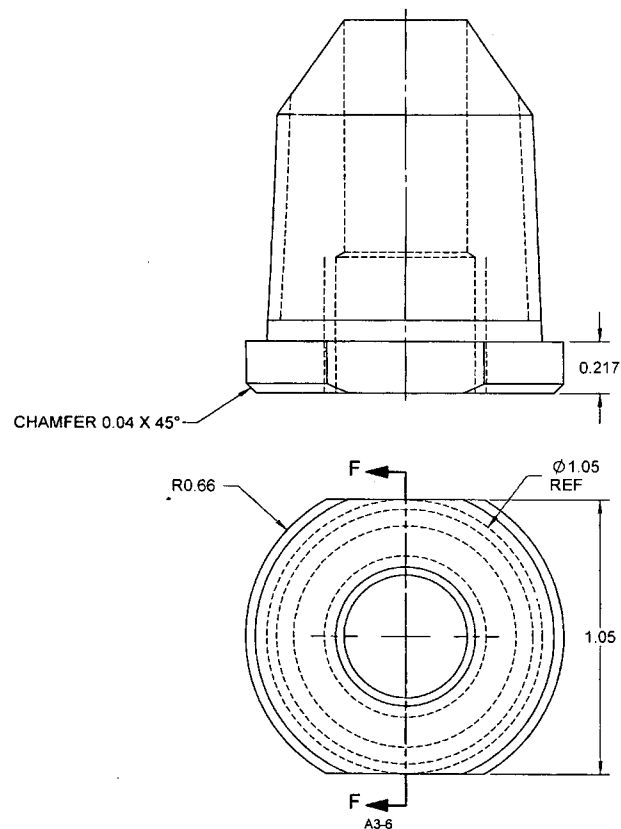
RELEASED
2010-05-05
WPD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4000	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 5 OF 8
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DE APPR.	<i>[Signature]</i>		NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-7	REF JCA-M47-1-10



SECTION F-F

A6-6

D4000-7 FUEL PICK UP FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

RELEASED
2010-05-05
JMD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4000	REV. A
MFG. APPR.			SHEET 6 OF 8
APPROVED		TITLE FITTING	SCALE
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-9	JCA-M47-1-11

DRILL $\phi 0.60$ THRU

$\phi 1.02$

G

G
83-7

0.13 x 45° CHAMFER

0.39

$\phi 0.709$ $\phi 0.748$

0.051

0.20

0.073

SECTION G-G

B6-7

D4000-9 GROMMET

RELEASED
2010-05-05
MD

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, $\phi 1.000$ ROUND BAR
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4000	SHEET 7 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
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D

C

B

D

C

B


 $\phi 0.50$

 0.032
REF

D4000-11 CAP
RELEASED
 2010-05-05
MB
NOTES:

 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027 OR ASTM B209
 REF DART SPEC M6061T6S.032

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>MB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MB</i>	D4000	SHEET 8 OF 8
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